



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBST2812-P
Job Sheet 188912



order 11120 21 Feb

Part No: RBST2812-P

Job Qty: 2 pcs

Part Name: Portable Tri-Roller Staking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST2800-P Rev. 1 IPP Rev. A 18.06.21 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	2/8/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 6	2 pcs	2/8/19		0.00	0.00	QC 6 - 38		DAS MAR 25 2019 9-89
							QC 6 - 42		
							QC 6 - 9		
							QC 6 - 68		
							QC 6 - 61		
130	Packaging 3-1 - Stock - B4B	2 pcs	2/8/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		
							Packaging 3 - 17 - B4B		
							Packaging 3 - 18 - B4B		
							Packaging 3 - 19 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165472



Part: RBST2812-P

Job No: 188912

Serial No/Batch: S165472

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 03/25/19

Plex 1/16/19 1:21 PM Dart.lajeunesse.marie

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140	QC 21 - FG	2 pcs	2/8/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

DAS

21

9-88 MAR 26 2019

Part Op 100 - (Small Fab) 1-Assemble as per DWG sheet 1. ***NOTE*** - Apply a light coat of corrosion prevention compound to Descriptions: assembly (LPS 1/2) See deviation. See note 1 and 2.

110 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location:) Identify and Stock

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
92383A202	Roll Pin	2 pcs (1 ea)	100-Small Fab - 1	5089124
95065A150	Distorted Thread Lock Nut	2 pcs (1 ea)	100-Small Fab - 1	5089130
99142A410	Internal Snap Ring	2 pcs (1 ea)	100-Small Fab - 1	5089125
CS075-H1	Crest to Crest Flat Wire Wave Spring	2 Ea (1 ea)	100-Small Fab - 1	-50893424
NTA-411	Bearing	2 Ea (1 ea)	100-Small Fab - 1	5033972
NTA-613	Bearing 13/16" Od X 3/8" Id (Applied)	2 Ea (1 ea)	100-Small Fab - 1	5087412
RBST2812-P-1	Base	2 pcs (1 ea)	100-Small Fab - 1	5121608
RBST2812-P-11	Dual Seat	2 pcs (1 ea)	100-Small Fab - 1	5122412
RBST2812-P-13	Receiver	2 pcs (1 ea)	100-Small Fab - 1	5121969
RBST2812-P-15	Tensioner	2 pcs (1 ea)	100-Small Fab - 1	5122415
RBST2812-P-3	Retainer	2 pcs (1 ea)	100-Small Fab - 1	5119966
RBST2812-P-5	Roller	6 pcs (3 ea)	100-Small Fab - 1	5111869
RBST2812-P-7	Cap	2 pcs (1 ea)	100-Small Fab - 1	5119984
RBST2812-P-9	Stud	2 pcs (1 ea)	100-Small Fab - 1	5122419
TRA-411	Washer	4 Ea (2 ea)	100-Small Fab - 1	5087249
TRA-613	Washer 13/16" Od X 3/8" Id (Applied)	4 Ea (2 ea)	100-Small Fab - 1	5150492

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	92383A202	2	98	0
	95065A150	2	96	0
	99142A410	2	50	0
	CS075-H1	2	9	0
	NTA-411	2	44	0
	NTA-613	2	9	0
	RBST2812-P-1	2	9	0
	RBST2812-P-11	2	10	0
	RBST2812-P-13	2	9	0
	RBST2812-P-15	2	9	0
	RBST2812-P-3	2	9	0
	RBST2812-P-5	6	17	0
	RBST2812-P-7	2	9	0
	RBST2812-P-9	2	9	0
	TRA-411	4	78	0
	TRA-613	4	10	0

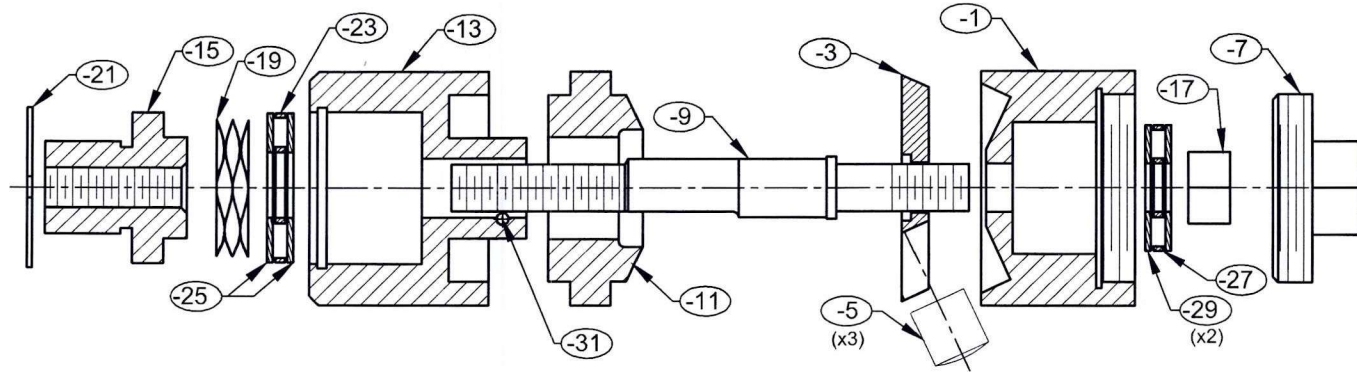
Part Specifications

Specifications could not be found.

Plex 1/16/19 1:21 PM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D -1, -3, -9 -11 & -13 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES. ADDED 2ND FLAT ON -13.	7/26/12	RJC
			SE



NOTES

- 5 ROLLERS AND -3 RETAINER MUST TURN SMOOTHLY ON -1 BASE WHEN ASSEMBLED.
- FLAT END OF -5 ROLLERS MUST FACE THE CENTER OF TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	BASE		SEE CHART	2
		-3	1	RETAINER		SEE CHART	3
		-5	3	ROLLER		SEE CHART	4
		-7	1	CAP		SEE CHART	5
		-9	1	STUD		SEE CHART	6
		-11	1	DUAL SEAT		SEE CHART	7
		-13	1	RECEIVER		SEE CHART	8
		-15	1	TENSIONER		SEE CHART	9
	B/O	-17	1	DISTORTED THREAD LOCK NUT	STEEL	1/4-20 UNC x 7/32 Ht. MCMaster-CARR #95065A150	1
	B/O	-19	1	CREST TO CREST FLAT WIRE WAVE SPRING	STEEL	.750 OD, .550 ID, WIRE THICK. .013, THREE TURNS SMALLEY RING CO. #CS075-H1	1
	B/O	-21	1	INTERNAL SNAP RING	STEEL	Ø7/8 BORE MCMaster-CARR #99142A410	1
	B/O	-23	1	THRUST BEARING (SPRING SIDE)	STEEL	Ø3/8 ID. x 13/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-613)	1
	B/O	-25	2	BEARING WASHER	STEEL	Ø3/8 ID. x 13/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-613)	1
	B/O	-27	1	THRUST BEARING	STEEL	Ø1/4 ID. x 11/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-411)	1
	B/O	-29	2	BEARING WASHER	STEEL	Ø1/4 ID. x 11/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-411)	1
	B/O	-31	1	ROLL PIN	STEEL	Ø3/32 x 3/8	N/S

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
206-010-470-101	RBST2812-P

RED BARN MACHINE

TITLE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOLS

DWG NO.	SEE CHART ABOVE FOR TOOL No.	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
TOLERANCES ON:	DRAWN BY: PERRITT	
XXX ± .005	APPROVED: <i>D. Weir</i>	
XX ± .01	HEAT TREAT	
X ± .1	FINISH	
FRACTIONS ± 1/32	SPEC	
ANGLES ± .5°	USED ON BEARING	
UNLESS OTHERWISE SPECIFIED	SEE CHART	
1. BREAK ALL SHARP EDGES	SCALE NTS	
.015 x 45° PR .015 R	DATE 11-9-09	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SHEET 1 of 9	